Work Order ID 120571

Wednesday, June 04, 2014 3:08:48 PM

120571

Item ID: D2600-3-BENT **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Extrusion Bent

Start Date: 6/04/14 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 6/04/14 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 14-06-09 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2600	Rev E
D2750	G

100 0.00

100

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo 0.00

Pick qty 1 D2600-3-130 extrusion

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

14-6-12

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC

Quality Control

Memo 0.00

DAS 03 8-89

14-6-12

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D2600-3-BENT **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Extrusion Bent

Start Date: 6/04/14 **Start Qty:** 10.00 *10*

Required Date: 6/04/14 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: L/6	0.00							
120						10	0	14-6-12	
Packaging	**Memo**	0.00							DGL
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130						MLJ		14-06-12	
QC	**Memo**	0.00							
Quality Control									

14-6-12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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General

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☐ Contamination
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☐ Cut Too Short
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☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, June 04, 2014 3:08:48 PM

Work Order ID: 120571 *120571*

Parent Item: D2600-3-BENT *D2600-3-BENT*

Parent Item Name: Extrusion Bent

Start Date: 6/04/14 **Required Date:** 6/04/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-130 *D2600-3-130* Extrusion Round 3" 350		Manufactured	No				Each	95.0000	**	10			

Location	Loc Qty	Loc Code
LG	95	
111665	29	
115858	66	

-10 DGL. 14-6-12.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Outside Dimensions
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221 (E)

 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
 MINIMUM ELONGATION = 8%

 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)

7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in

8) NO TOOLING MARKS

9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
 D2600-1 EXTRUSION MANUFACTURED FROM:

 - CARADON INDALEX DIE # MH-18870
 - SIGNATURE ALUMINUM (BON-L) DIE # 897121

10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
 D2600-3 EXTRUSION MANUFACTURED FROM:

 - CARADON INDALEX DIE # MH-18859
 - SIGNATURE ALUMINUM (BON-L) DIE # 897122

11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
 D2600-5 EXTRUSION MANUFACTURED FROM:

 - CARADON INDALEX DIE # MS-18871

12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
 D2600-7 EXTRUSION MANUFACTURED FROM:

 - CARADON INDALEX DIE # MS-18872

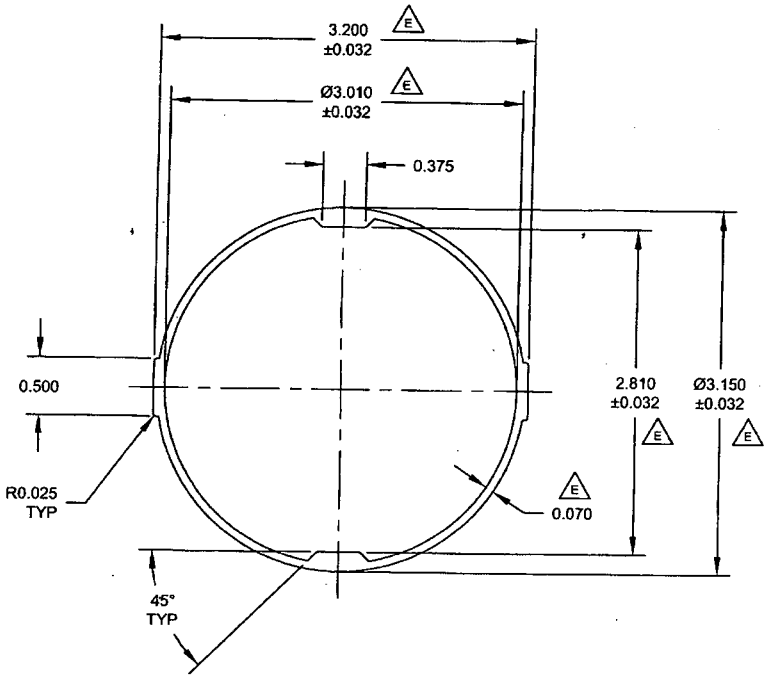
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120531 MLJ
14-06-09

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2012 -01- 11

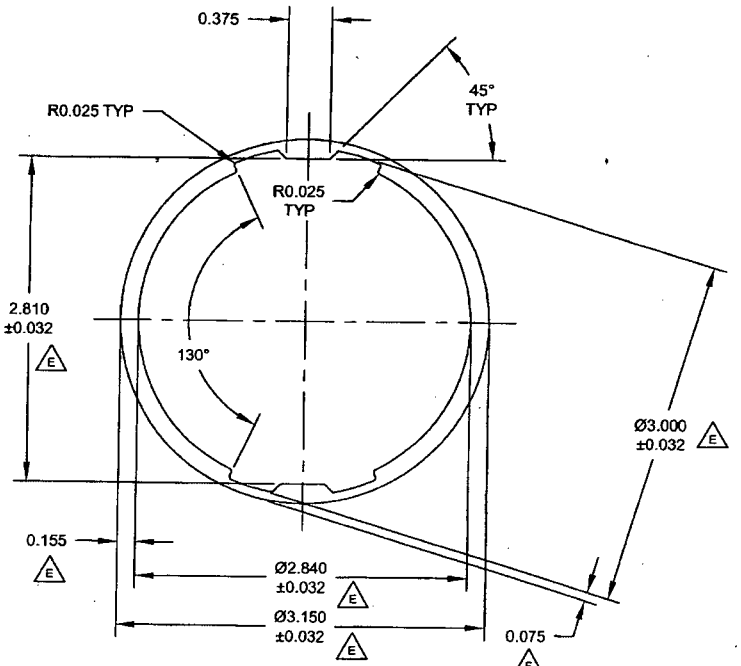
REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.		D2600	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	11.10.18		

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D2600-1 EXTRUSION

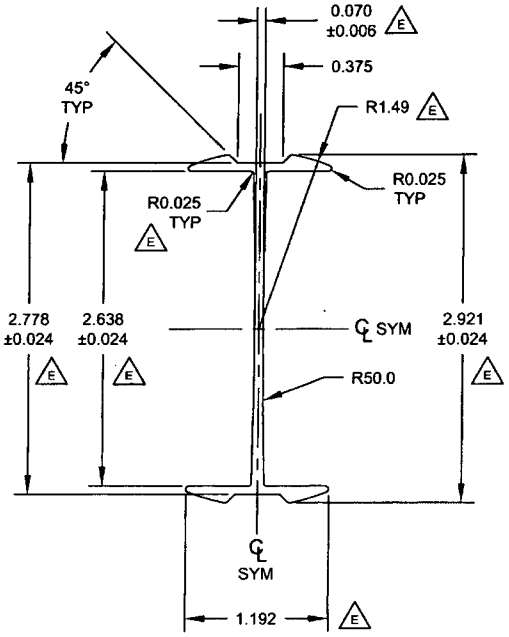


D2600-3 EXTRUSION

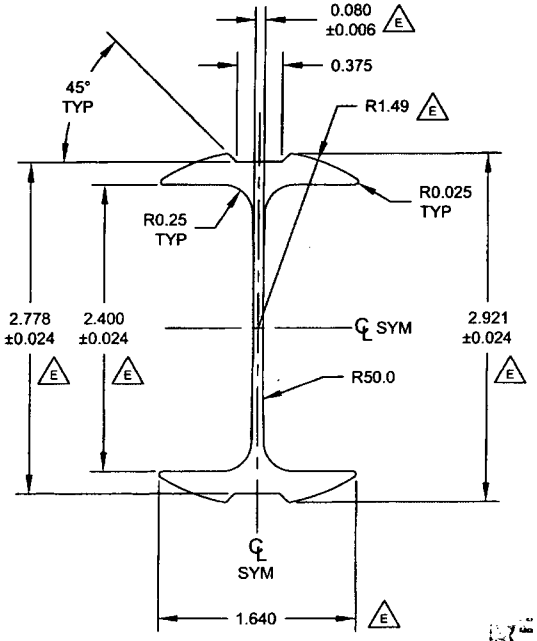
RELEASED
2012 -01- 10

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	AS	DRAWING NO. D2600 REV. E
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE EXTRUSION SCALE NTS
DE APPR.		
DATE	11.10.18	

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D2600-5 EXTRUSION



D2600-7 EXTRUSION

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2012-01-11

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2600 SHEET 3 OF 3
APPROVED		TITLE SCALE
DE APPR.		EXTRUSION NTS
DATE 11.10.18		

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

RELEASED
2013 -08- 13

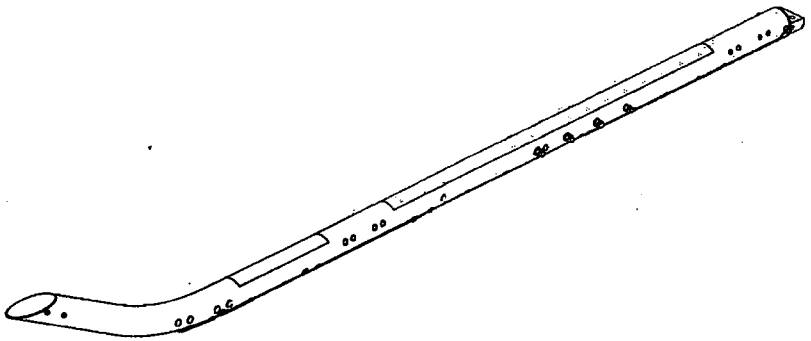
GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 (G) OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

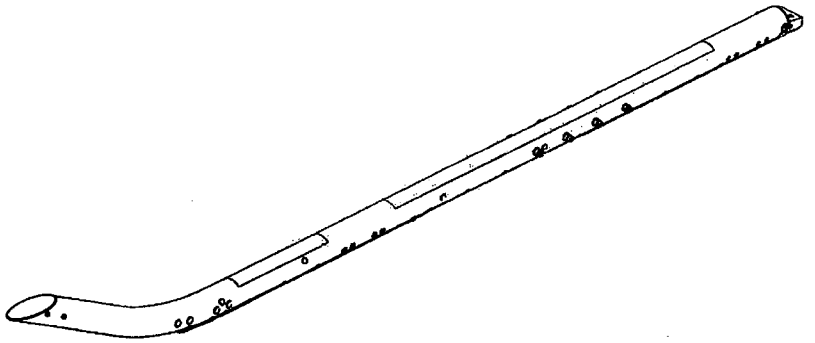
REV.	DESCRIPTION	BY	DATE
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750 REV. G
MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.07.11	

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

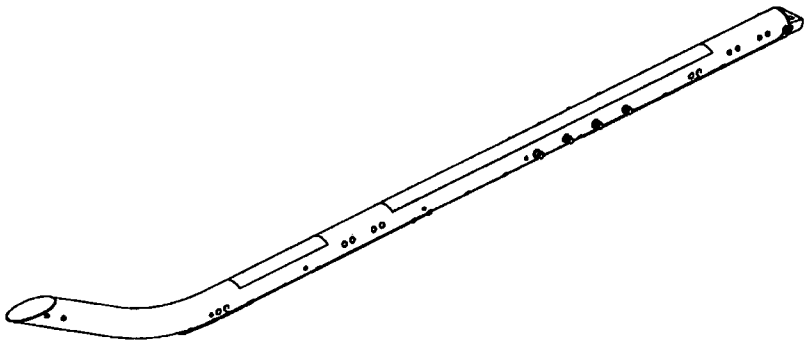


D2750-042 350 SKIDTUBE ASSEMBLY, RH

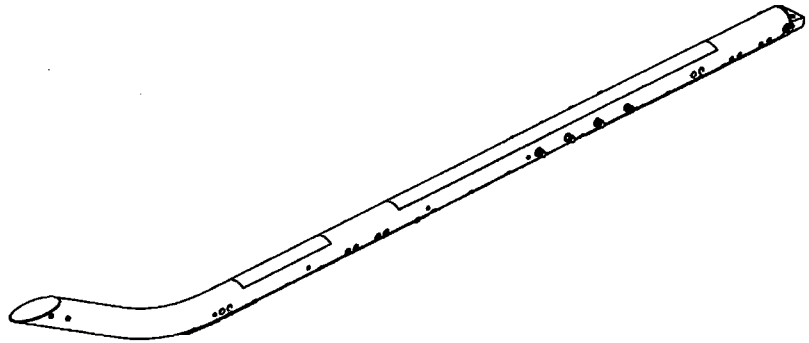
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2013 -08- 13

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. G
MFG. APPR.		SHEET 2 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 13.07.11		

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

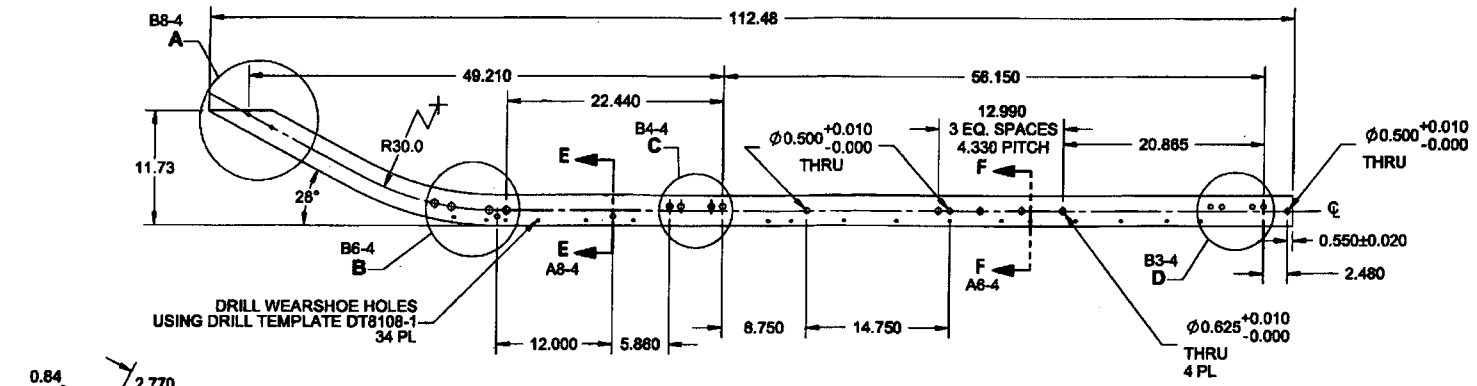


D2750-044 350 SKIDTUBE ASSEMBLY, RH

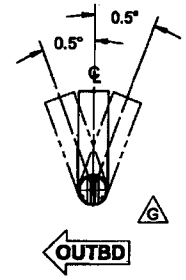
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DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. G
MFG. APPR.		SHEET 3 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 13.07.11		

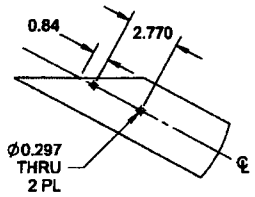
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D2750-1 LH SKIDTUBE

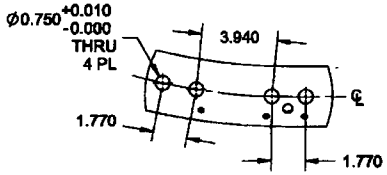


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



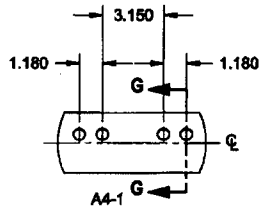
D7-4

DETAIL A
SCALE 2X



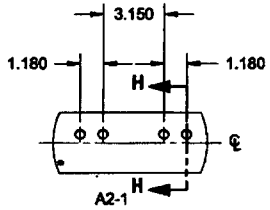
D7-4

DETAIL B
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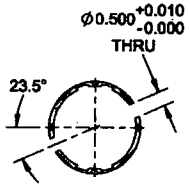
D5-4

DETAIL C
SCALE 2X



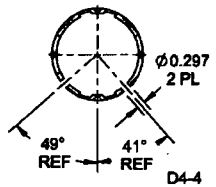
D3-4

DETAIL D
SCALE 2X



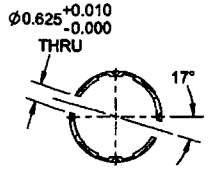
D6-4

SECTION E-E
SCALE 3X, 2 PL



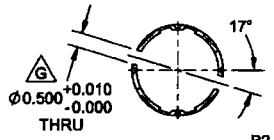
D4-4

SECTION F-F
SCALE 3X, 17 PL



B4-4

SECTION G-G
SCALE 3X, 4 PL



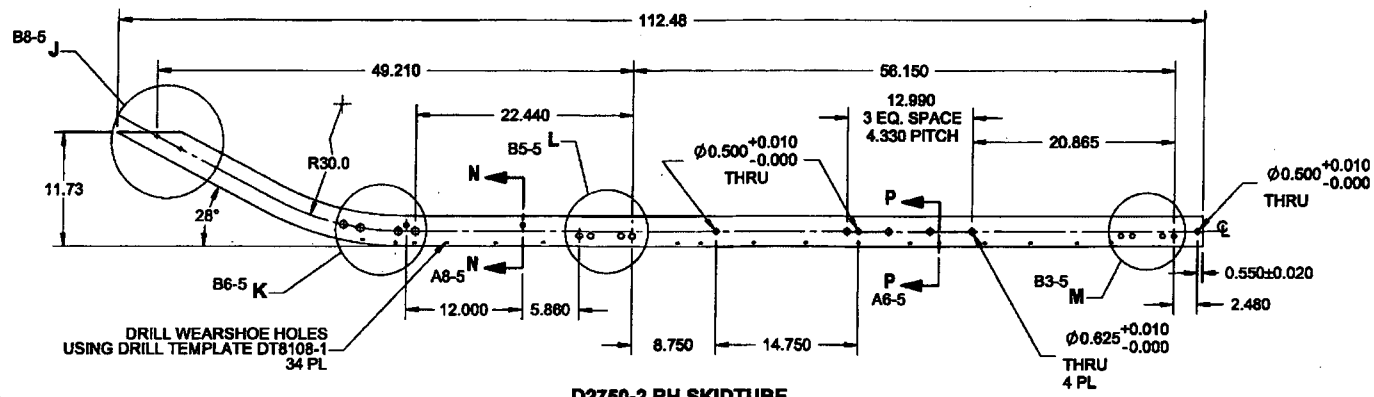
B2-4

SECTION H-H
SCALE 3X, 4 PL

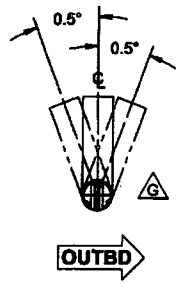
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DRAWN		
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APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	13.07.11	

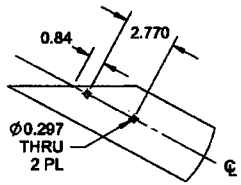
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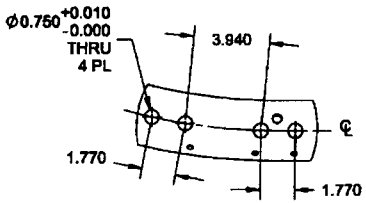
D2750-2 RH SKIDTUBE



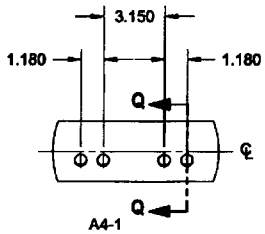
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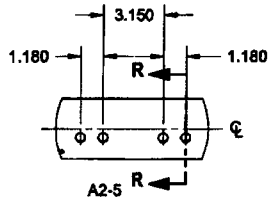
DETAIL J D8-5
SCALE 2X



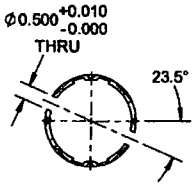
DETAIL K C7-5
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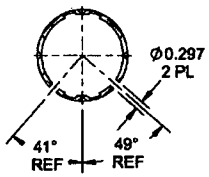
DETAIL L D6-5
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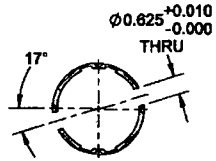
DETAIL M C3-5
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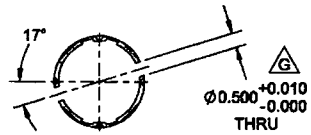
SECTION N-N C6-5
SCALE 3X, 2 PL



SECTION P-P C4-5
SCALE 3X, 17 PL



SECTION Q-Q B5-5
SCALE 3X, 4 PL

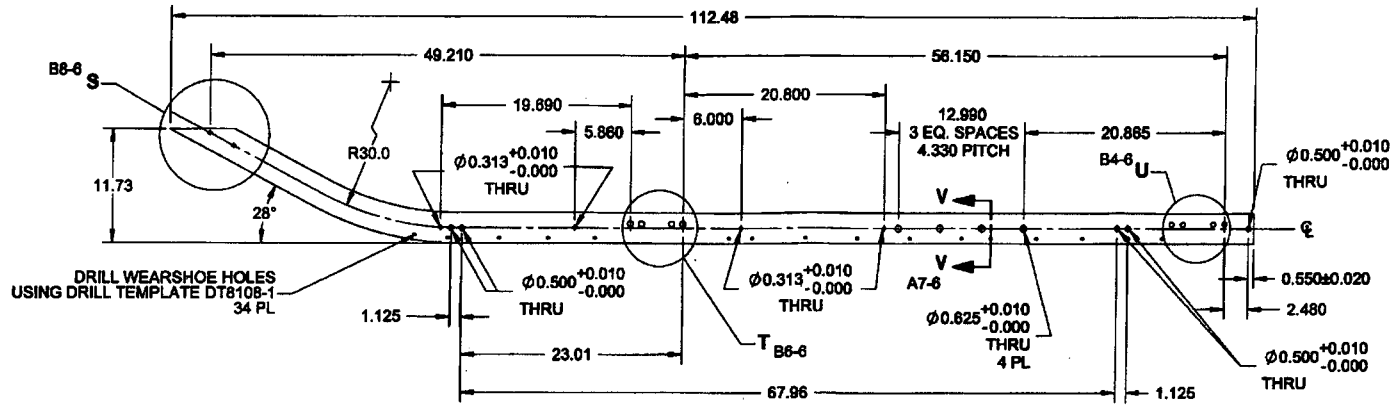


SECTION R-R B3-5
SCALE 3X, 4 PL

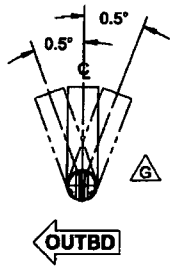
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DRAWN		DRAWING NO. D2750 REV. G
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MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
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DATE	13.07.11	

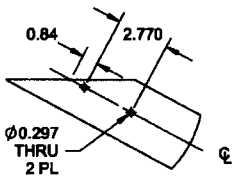
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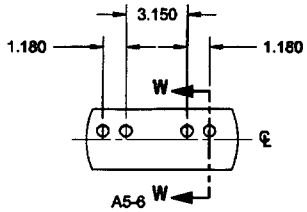
D2750-3 LH SKIDTUBE



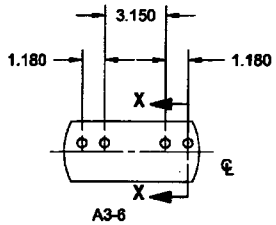
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



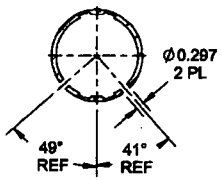
DETAIL S D8-6
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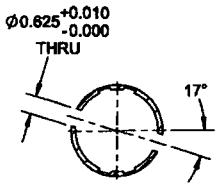
DETAIL T C5-6
SCALE 2X



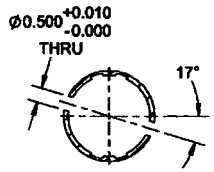
DETAIL U D3-6
SCALE 2X



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL

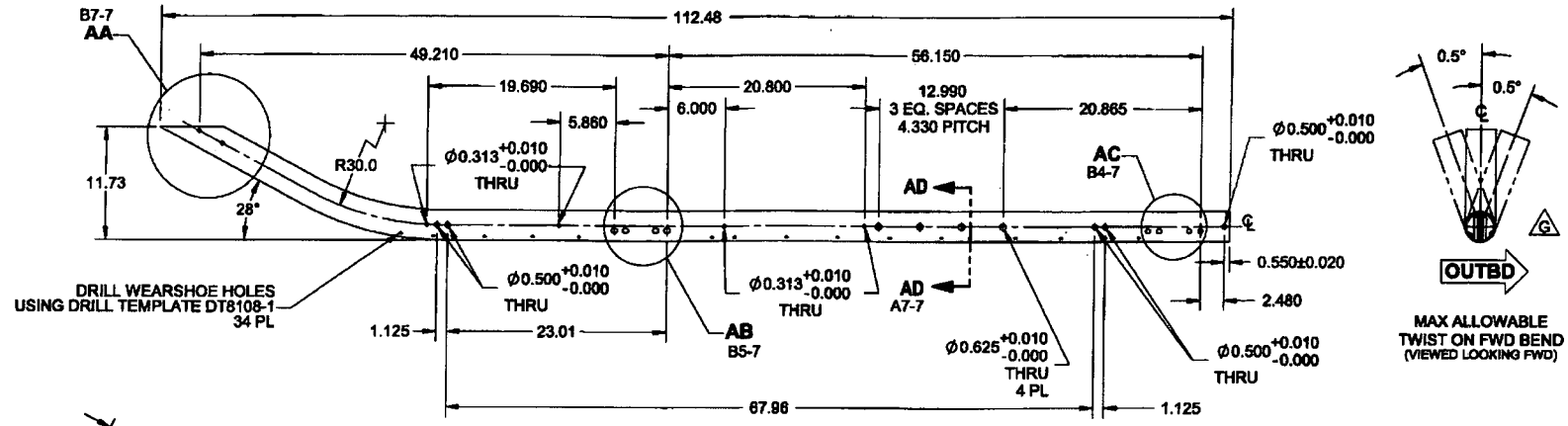


SECTION X-X B4-6
SCALE 3X, 4 PL

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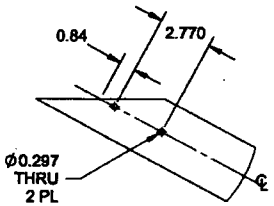
DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA	
DRAWN		DRAWING NO. D2750	REV. G
CHECKED			SHEET 6 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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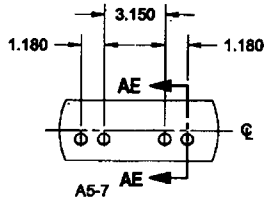


D2750-4 RH SKIDTUBE

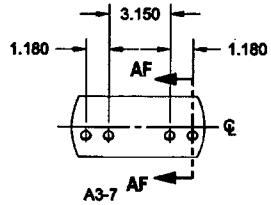
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



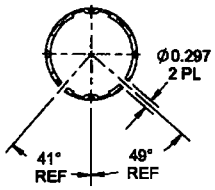
DETAIL AA D7-7
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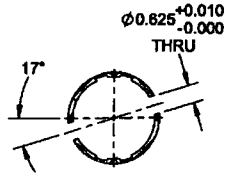
DETAIL AB C4-7
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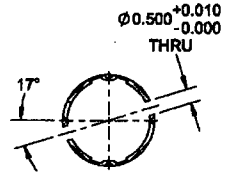
DETAIL AC D3-7
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SECTION AD-AD D3-7
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SECTION AE-AE B6-7
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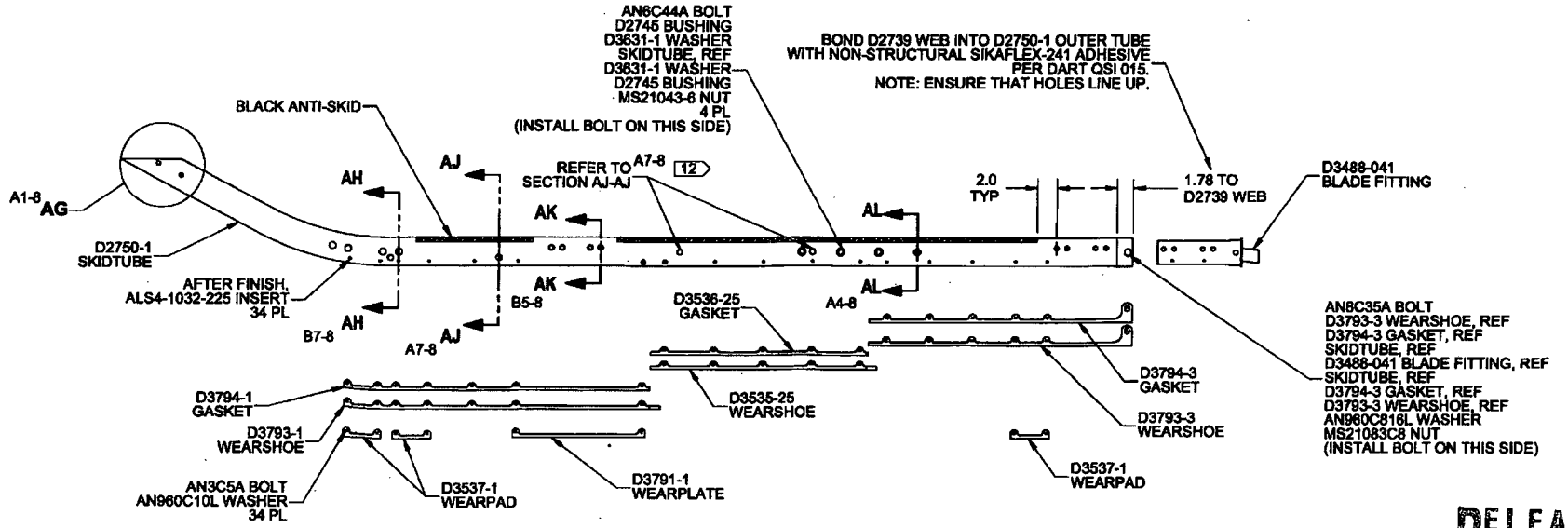


SECTION AF-AF B4-7
SCALE 3X, 4 PL

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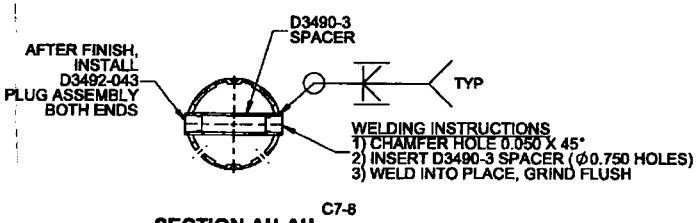
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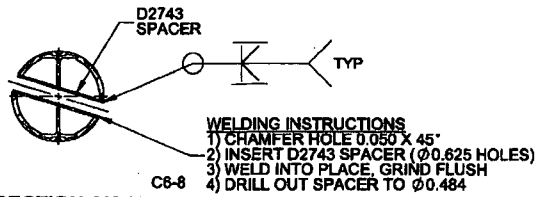


D2750-041 350 SKIDTUBE ASSEMBLY, LH

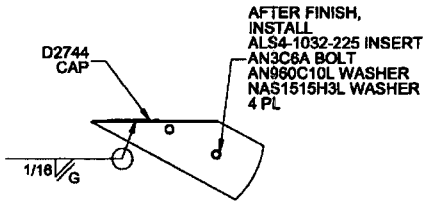
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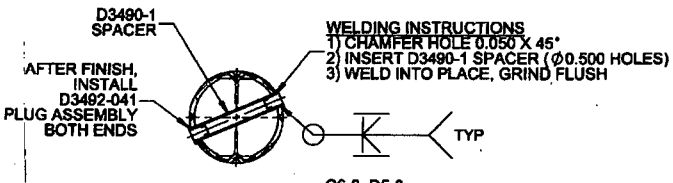
SECTION AH-AH
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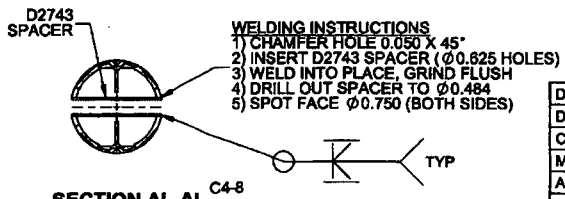
SECTION AK-AK
SCALE 3X, 4 PL



DETAIL AG
SCALE 2X



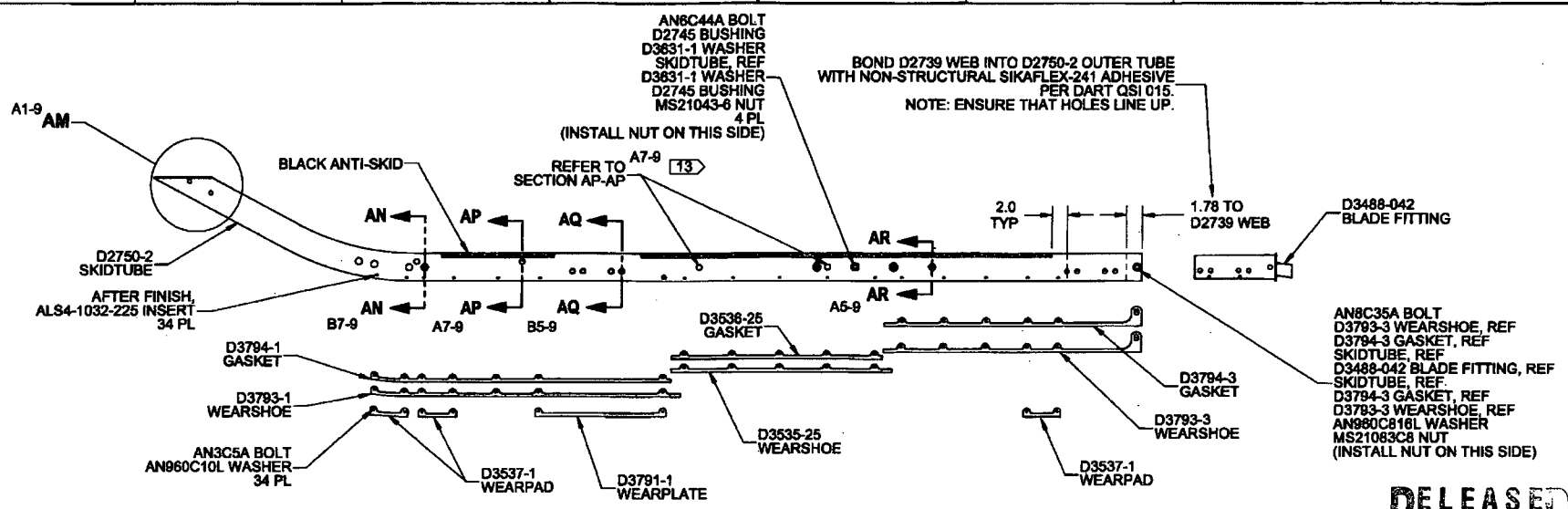
SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
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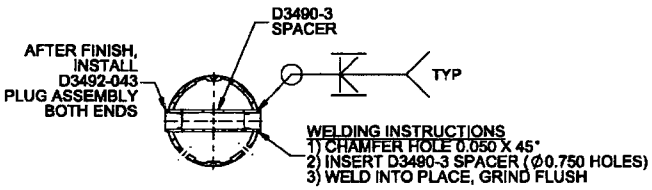
DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. G
MFG. APPR.		SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
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DATE	13.07.11	

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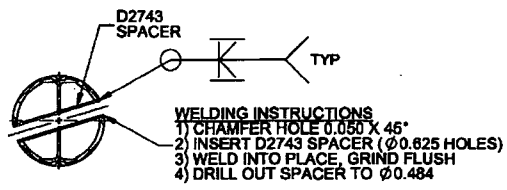


D2750-042 350 SKIDTUBE ASSEMBLY, RH

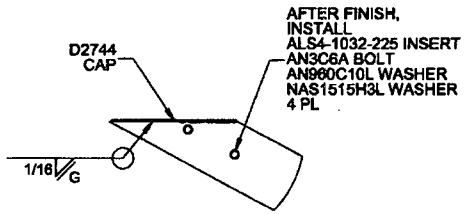
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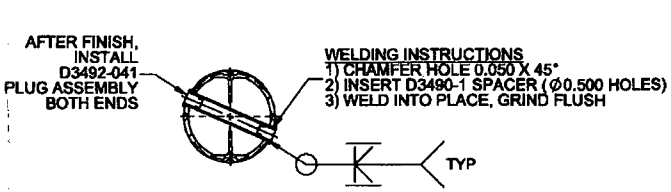
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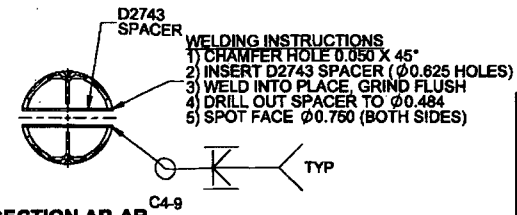
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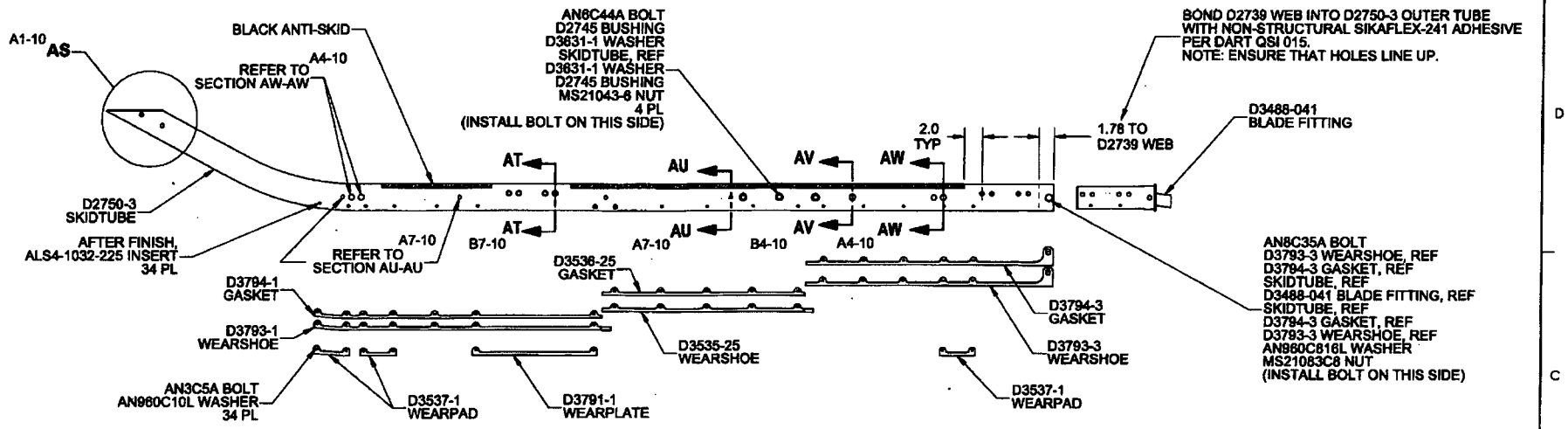
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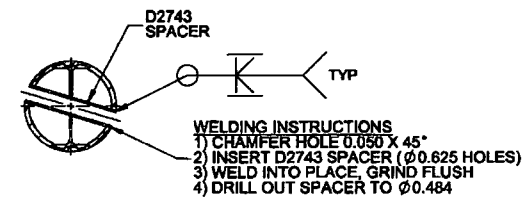
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CHECKED		SHEET 9 OF 11
MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	13.07.11	

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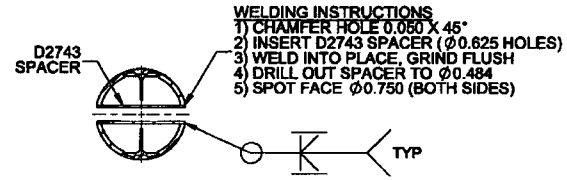
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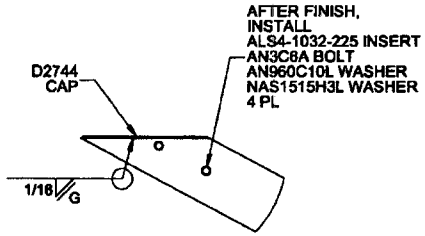
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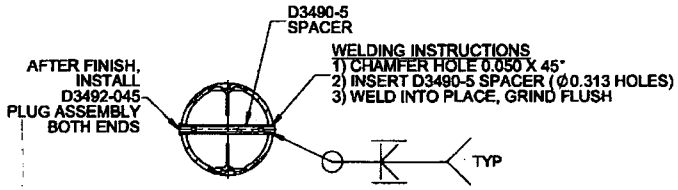
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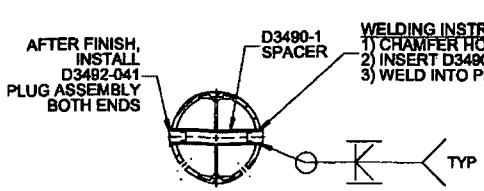
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DETAIL AS
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D5-10, D6-10

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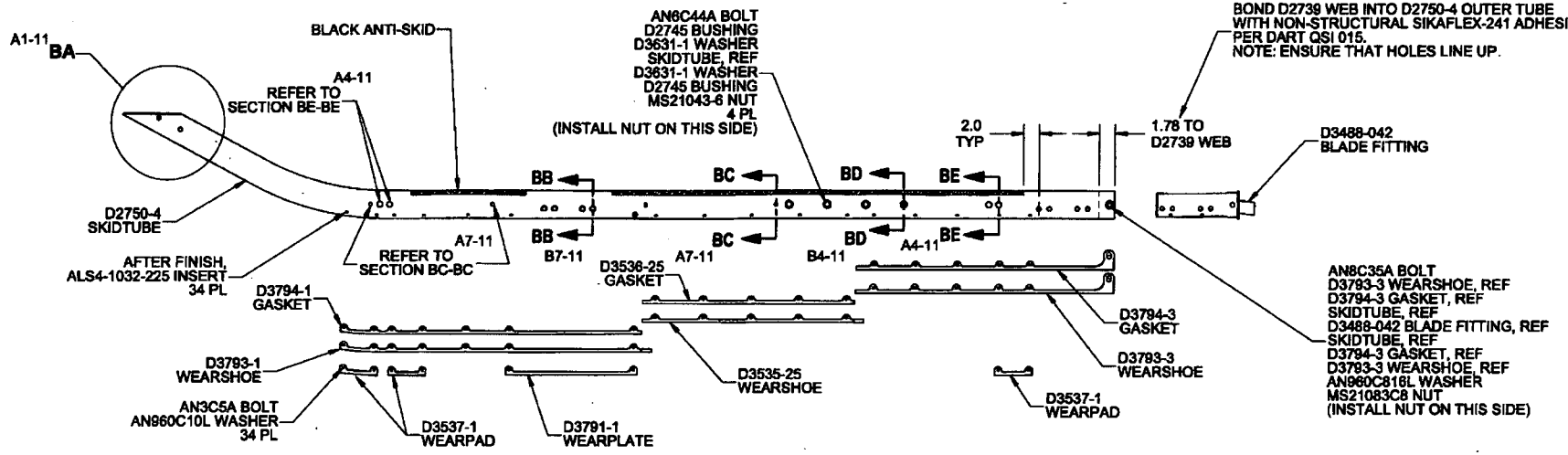


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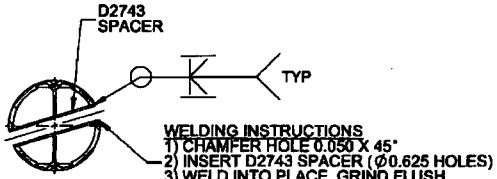
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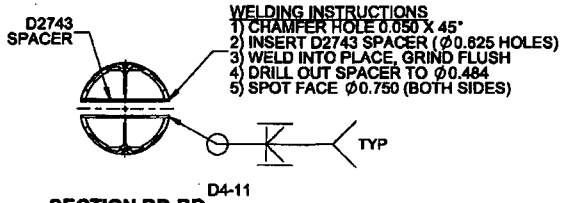


D2750-044 350 SKIDTUBE ASSEMBLY, RH

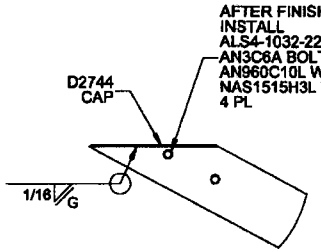
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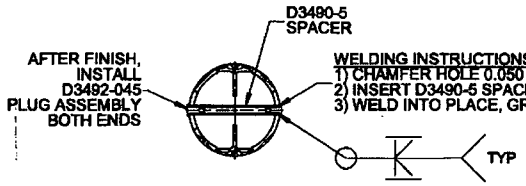
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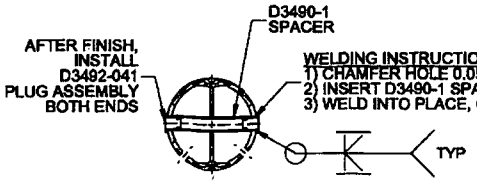
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(HARDWARE REMOVED FOR CLARITY)



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

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